

**Work Order ID 62036**

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Wednesday, September 15, 2010 10:18:20 A

Item ID: D206-559-023

Accept



Setup Start



Revision ID:

Item Name: Bearpaw

Stop



Start Date: 9/15/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 9/16/2010 Req'd Qty: 5.00



Customer:

Reference: ECN 10-613

Approvals:

Process Plan: MFDate: 10-9-15

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN-D206-559	J -PRELIM

200



Packaging

Memo 0.00

Packaging

PULL FROM STOCK D206-559-023

B 41731 X 5

REMOVE AN4-15A BLOTS AND REPLACE WITH AN4-20A

MEL WILL MAKE AN ADJ

UPDATE PAPERWORK AND LABELS TO CHANGE 7

210



QC4- 100% Inspect kits for completeness

QC

Quality Control

0.00

0.00

S. Warko

10/9/16 MF 52XS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 62036**

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Wednesday, September 15, 2010 10:18:20 A

Item ID: D206-559-023

Accept



Setup Start



Revision ID:

Item Name: Bearpaw

Stop



Start Date: 9/15/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 9/16/2010 Req'd Qty: 5.00



Customer:

Reference: ECN 10-613

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

220



Packaging

Packaging

Operation  
DescriptionIdentify as per dwg & Stock Location: 12Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Ran B

10/16/10

50

230



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/09/10

MF

10-9-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Picklist Print

Wednesday, September 15, 2010 10:18:19 AM

Page 1

**Work Order ID:** 62036



**Parent Item:** D206-559-023



**Parent Item Name:** Bearpaw

**Start Date:** 9/15/2010

**Required Date:** 9/16/2010

**Comments:** IPP Rev: E 04.02.17 Tolerance added to Step 3 KJ/LJM  
IPP Rev: F 07-01-02 Was K10006 JLM  
IPP Rev:G 08-09-19 Added step 2 JLM Verified By:EC  
IPP Rev:H New Manufacturing Method 08-10-29 JLM Verified By:EC

**Start Qty: 5.00**

**Start Qty: 5.00**      **Required Qty: 5.00**

**Start Qty: 5.00**      **Required Qty: 5.00**

**Start Qty: 5.00**

**Required Qty: 5.00**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**REFERENCE ONLY**

5.0 PARTS LIST (D206-559 REV. K)  
32.7 PARTS LIST (ICA-D205-559 REV. 2)

Qty -011	Qty -013	Qty -021	Qty -023	Qty -031	Qty -033	Qty -113	Part Number	Description
X							D206-559-011	Bearpaw Kit 206 A/B
	X						D206-559-013	Bearpaw Kit 206 L/L1/L3/L4/407
		X					D206-559-021	Narrow Bearpaw Kit 206 A/B
			X				D206-559-023	Narrow Bearpaw Kit 206 L/L1/L3/L4/407
				X			D206-559-031	Wearplate Kit
					X		D206-559-033	Wearplate Kit
						X	D407-559-113	Large Bearpaw Kit 206 L/L1/L3/L4/407
4	6	4	6				D2182B050	RUBBER CUSHION
8	12	8	12			20	D2274	RADIUS BLOCK
2							D2435	19" X 16" BEARPAW
	2						D2432F	19" X 24" BEARPAW
		2					D2671	13" X 16" BEARPAW
			2				D2672F	13" X 24" BEARPAW
4	6	4	6				D2438	CLAMP
8	12	8	12				D2529	WASHER
	6		6				D2732-050	RUBBER CUSHION
					2		D3456-1	WASHER
						2	D3859-041	WEARPLATE
					2		D3860-041	WEARPLATE
						2	D4010-041	BEARPAW ASSEMBLY
						8	D4011-1	CLAMP, SHORT
						2	D4011-3	CLAMP, LONG
						8	D4011-5	CLAMP, SHORT (OEM)
						10	D4012-1	CUSHION
						2	AN4C10A	BOLT
8	12	8	12	8	12		AN4-17A	BOLT
8	12	8	12	8	12		AN4-20A	BOLT (WAS AN4-15A)
						4	AN4C13A	BOLT
						8	AN4C15A	BOLT
						8	AN4C17A	BOLT
16	24	16	24				AN960JD416	WASHER (OR NAS1149D0463J)
8	12	8	12	8	12		MS21042L4	NUT (OR MS21042-4)
						20	MS21043-4	NUT
					8	12	NAS1149D0463J	WASHER (OR AN960JD416)
2		2					QS200M44S	CLAMP

CANADA	
DEPARTMENT OF TRANSPORT	
AIRCRAFT CERTIFICATION	
BRANCH	
DAO # 01-O-01	
APPROVED	
BY:	<i>[Signature]</i>
D. SHEPHERD (DE # 02)	
DATE:	10.06.30
CERT. NO.:	SH92-17
ISSUE NO.:	7

DESIGN	<i>gp</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>gp</i>		
CHECKED	<i>1</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9527	SHEET 2 OF 2
APPROVED	<i>MD</i>	TITLE	SCALE
DE APPR.	<i>MD</i>	BOLT CHANGE	NTS
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